Work Orde Wednesday, May													Page 1
Revision ID:	D3566-1 Gasket			A	ccept					Setup S	Start Stop		
Start Date: Required Date: Reference:		Start Qty: 20. Req'd Qty: 20.			$\mathcal{L} = \mathcal{U}$	Cust Ite Custome							1818 (18 1181 1 5 8)
Approvals:	Process Plan	:	Date:	16-5-20	Tooling: SPC (Y/N):	,	Date:		i		Start Stop	1 18893181 81	
Sequence ID/ Work Center ID		Operation Description			Set Up/ Run Hours	Tool II	Tool #	Plan Code	Accept Qty	Rejec Qty		keject lumber	Insp. Stamp
Draw Nbr	Revis	ion Nbr							~ · · ·			- unitoti	Stamp
D3566	Rev C		·										
Waterjet FLOW CNC Waterje			per Dwg D356	6 □Dwg Rev:	0.00 0.00 □ Prog Rev:_	<u> </u>			Th3	, (0 -	6-	<u> </u>	
QC Quality Control	(QC2- Inspect parts o Memo	-	/FAIB	0.00					10-6	_4_	(92)	<u> </u>
120 QC Quality Control	(QC8- Inspect parts - Memo	second check		ارس کی اور ا	66164		(d	422		<u>-</u> _		

Dail Acidsbace Liu	Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	! !								
,								=	
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ A	\ :	Date:	
		esolution:							
NCR:		1	WORK ORI	DER NON-CONFORMA	NCE (NCR)	_		
DATE STEP		Description of NC	Corrective Action Section B			Verific	Verification Ap		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
	·							<u> </u>	
							•		
			·						

Work Order ID 59126

Wednesday, May 26, 2010 1:27:33 PM



Page 2

Item ID:

D3566-1

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Gasket 5/26/2010

Start Qty: 20.00

Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

	_
An	nrovolee
Ab	provals:

Process Plan:

Date:_____

Tooling:

Date:

Run Start



QC:

Required Date: 6/4/2010

Date: _____

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

QC21- Final Inspection - Work Order Release

0.00



Quality Control

0.00

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHAN	GES					
DATE	STEP	PROCEDURE CHANGE				у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
····										
Part No		PAR #:								
	Res	olution:							Date: _	
NCR:			WORK ORDE	R NON-CONFORM	IANCE (I	NCR)				
DATE	STEP	Description of NC	Initial	ction B	ion B V		ation	Approval	Approval	
		Section A	Chief Eng	Action Description Chief Eng		Date	Section	on C	Chief Eng	QC Inspector
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	1 1] .

Picklist Print

Wednesday, May 26, 2010 1:27:37 PM

Work Order ID: 59126

Parent Item:

D3566-1

Parent Item Name: Gasket

Comments:

IPP Rev:A IPP Rev:B

New Issue 07-03-08 ec

IPP Rev:C

Added Drain Holes 07-07-09 JLM

As per Rev C 07-09-09. JLM Verified By:EC

Start Date: 5/26/2010

Required Date: 6/4/2010

Page 1

Status

Start Qty: 20.00

Required Qty: 20.00

Date

Component Item ID/

MNEO60S.063

Replacement Mfg/

Purchased

Bin **Primary** No

Last

Route 100

Unit of sf

Qty on 479.2531

Loc Code

Qty per Kit Total 0.911

19.17895

Qty

20,

NEOPRENE SHEET 0.063

Location MAT

114691

MAT052

114176

Loc Qty 374 374

105.2531 105.2531

114691

DART AEROSPACE LTD	Work Order:	59124		
Description: Gasket	Part Number:	D3566-1		
Inspection Dwg: D3566 Rev: C		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+/-0.030	3,(01	8			
+/-0.030		~			***
+/-0.030		7	_		
+/-0.030					
+/-0.030	1				
+/-0.030					
+/-0.030					
+/-0.030					
+/-0.010		W .			
+0.005/-0.001	190	y			
	+/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.010	Tolerance Dimension +/-0.030 3,(も) +/-0.030 18.00 +/-0.030 12.10 +/-0.030 2.443 +/-0.030 6.00 +/-0.030 1.40 +/-0.030 303 +/-0.030 303 +/-0.010 ,のらう	Tolerance Dimension Accept	Tolerance Dimension Accept Reject	Tolerance Dimension Accept Reject Inspection +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030 +/-0.030

Measured by: 12	Audited by:	Prototype Approval:	N/A
Date: 10-6-4	Date: (o below	Date:	N/A

A 07.03.14 New Issue		
A 07:00.14 New Issue	KJ/JLM	
B 07.07.18 Dimensions updated per Dwg Rev. B	KJ/JLM	
C 07.09.26 Dwg Rev updated	KJ/EC/DD	E

Dart Aerospace	Ltd
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
	1												
Part No	:	PAR #:	Fault Cate	egory:	_ NCR:	Yes N	o DQ	A :	Date: _				
Resolution: D													
NCR:			WORK ORD	ER NON-CONFORM	ANCE (I	VCR)							
DATE	STEP	Description of NC	NC			ction B			Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section	on C	Chief Eng	QC Inspector			
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										!			
			1 1		1		I		1	1			

RETURN TO ENGINEERING UNCONTROLLED CONV SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 59/26 PS (6-5-26) 30.00 ◬◬ ◬◬ DETAIL A (REF) Ø0.19 Ø0.19 DETAIL A D (3 PLACES) Đ (4 PLACES) 3.10 **--** 6.00 **--**2.43 38.50 18.00 2.43 **EQUAL SPACES** 3 EQUAL SPACES 3.10 5.50 PITCH 6.00 PITCH D3566-5 GASKET **D3566-1 GASKET** DETAIL A - DETAIL A ▲ DETAIL A Ø0.19 1.25 - 2.43 **. G** 2.43 Ø0.19 (2 PLACES) (2 PLACES) 2.50 (REF) 23.50 EQUAL SPACES 5.88 PITCH (REF) D3566-7 GASKET **D3566-13 GASKET** D3566-15 GASKET ∕6\ В **RELEASED** 07.08.04. R0.11 R0.38 UPDATE DRAWING TEMPLATE: CHANGE ALL (TYP X PLS) TO (X PLACES); С A8: UPDATE NOTES: CB 07.08.21 A8, B2: ADD D3566-15; 0.30 A5. INCREASE SIZE OF DETAIL A; 0.19 В ADD DRAIN HOLES PH 07.04.17 Α NEW ISSUE PH 06.12.18 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER REV. DESCRIPTION BY DATE (REF DART SPEC M-NEO60-S.063) DESIGN DART AEROSPACE LTD Α 2) FINISH: NONE DRAWN 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED HAWKESBURY, ONTARIO, CANADA 4) UNITS: INCHES UNLESS OTHERWISE NOTED CHECKED DRAWING NO. REV. C WEIGHTS: 5) BREAK SHARP EDGES: N/A MFG. APPR D3566 D3566-1 0.29 lbs SHEET 1 OF 1 6) IDENTIFICATION: NONE 0.36 lbs APPROVED D3566-5 TITLE SCALE 7) WEIGHT: SEE TABLE IN ZONE A3 0,24 lbs D3566-7 GASKET DE APPR. 8) PARTS ARE SYMMETRIC ABOUT C D3566-13 0.07 lbs DATE COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS MINITED AND COMPOSETTIVE AND IS SUPPLED ON THE DIPPLES COMMITTED THAT IT IS

NOT TO BE USED FOR ANY INVENOUS ON COMPANIESTED TO ANY OTHER PERSON WITHOUT D3566-15 0.15 lbs 07.08.21 4 3

SHOPCOPY

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No			Fault Category:			ICR: Yes No DQA: Date:					
	R	esolution:	Disposit	QA	: N/C Cld	sed:		Date:			
NCR:		,	WORK OR	DER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Sec				Verific	ation	Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Section		Chief Eng	QC Inspector	
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